

Date: Monday, 03/11/2008 1:31:27 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 43172			Part Number	: D35911	
Estimate Number	: 12686			Drawing Number	: D3591 REV B	
P.O. Number	:			Project Number	: N/A	
This Issue	: 03/11/2008	S.O. No. :		Drawing Revision	: B	
Prsht Rev.	: NC			Material	:	
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 19/11/2008	Qty: 40 Um: Each
Previous Run	: 41140					
Written By	:					
Checked & Approved By	<u>JCD 08-11-03</u>					
Comment	: EST A 07.02.01 new issue EC Est Rev:B 08-09-10 revB as per dwg DD verified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W
		Comment: Qty.: 0.3675 f(s)/Unit Total : 14.7000 f(s) 304 RD Tube .500 x .035W Batch: 1108250 <u>DTP 08/11/10</u>
2.0	LATHE CONV. <u>Cobra</u> <u>08/11/08</u>	CONVENTIONAL LATHE
		Comment: CONVENTIONAL LATHE <u>CORBA</u> 1-Turn as per dwg D3591
		(40)
	2-Deburr	<u>DTP 08/11/10</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		(40)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>DTP 08/11/10</u>
4.0	QC8	SECOND CHECK
		(40)
		Comment: SECOND CHECK <u>mk</u> <u>08/11/10</u>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		(40)
		Comment: PACKAGING RESOURCE #1 <u>BS</u> <u>08/11/12 x90</u> Identify and Stock Location: <u>Bankley</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 03/11/2008 1:31:27 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 43172

Part Number: D35911

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/11/12
d/j

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43172
Description: Bushing	Part Number:	D3591-1
Inspection Dwg: D3591	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>JSP</u>	Audited by:	<u>AKL</u>	Prototype Approval:	N/A
Date:	08/11/10	Date:	08/11/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	DS

8 7 6 5 4 3 2 1

D

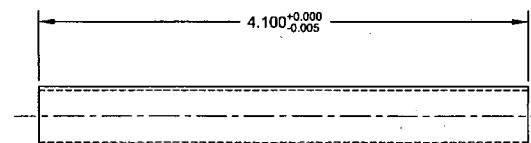
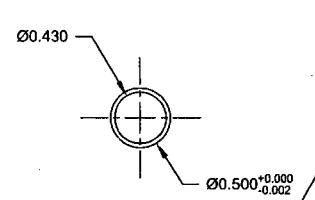
D

C

C

B

B

**D3591-1 BUSHING****RELEASED**
(09-09-07)

NO. *WKA 377*
 SHOP COPY
 RETURN TO
 ENGINEERING COPY
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS, Ø0.500, 0.035 WALL SEAMLESS ROUND TUBING
REF. DART SPEC M304TR0.500W.035
OR: AISI 303/304/316 SS, ROUND BAR
REF DART SPEC M303R/M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

B	DRAWING UPDATED TO "B" SIZE FORMAT AND CURRENT STANDARDS. ZN C6 TOLERANCE WAS -0.005. MATERIAL UPDATED TO ALLOW PART TO BE MACHINED TO MANTAIN TOLETANCE. (SEE NCR 08-074 FOR FURTHER DETAILS.)			AJS	08.08.25
A	NEW ISSUE			PH	07.01.16
REV.	DESCRIPTION			BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS	DRAWING NO.	REV. B		
CHECKED		D3591	SHEET 1 OF 1		
MFG. APPR.		APPROVED	TITLE	SCALE	
DE APPR.			BUSHING	NTS	
DATE	08.08.25				

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8 7 6 5 4 3 2 1

A

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